

ASAP

Date: Monday, 12/10/2007 12:04:15 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STRUT	
Job Number	36226		Part Number	D35501	
Estimate Number	12704		Drawing Number	D3550 REV.B	
P.O. Number	N/A		Project Number	N/A	
This Issue	12/10/2007 S.O. No. N/A		Drawing Revision	B	
Prsht Rev.	NC		Material	N/A	
First Issue	MA		Type	MACHINED PARTS	
Previous Run	32450		Due Date	12/17/2007 Qty: 20 Um: Each	
Written By					
Checked & Approved By					
Comment	Est. A 07.02.05 New issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304TR0500W049	304 RD Tube .500 x .049W
	Comment: Qty.: 1.7850 f(s)/Unit Total: 42.033	42.033
	304 RD Tube .500 x .049W	
	304/316 Seamless tubing ,½" OD x .049 Wall	Batch M104862 SB 07/12/10 20
2.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE	
	1-Form per Dwg D3550	07/08/12
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	SAD 07-12-18 19
	Deburr if necessary.	RT
4.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/12/18 X15
5.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING	m/059/14
	Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	FZ 07/12/19 5

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr
						Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/12/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/18	2.0	One part scrap, didn't form correctly R.C. no jig for forming the flat ends. the flat ends.	<input checked="" type="checkbox"/> Pasiurz	Scrap, destroy no replace made jigs for forming flat end on part	SAD 07/12/18 07/12/18 07/12/18	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> Pasiurz	<input checked="" type="checkbox"/> 07/12/18
07/12/18	2.0	Four (4) parts have the hole off center by .005" to .060". R.C. Human error	<input checked="" type="checkbox"/> Pasiurz	Scrap the four (4) parts. no replace	SAD 07/12/18 07/12/18	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/> Pasiurz	<input checked="" type="checkbox"/> 07/12/18
		error		Total amount scrap is 75 on the whole				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 36226

Part Number: D35501

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



AS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-19

(X15)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 271

AS

07/12/19

(X15)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/19

(15)

Job Completion



AS 2007/12/20

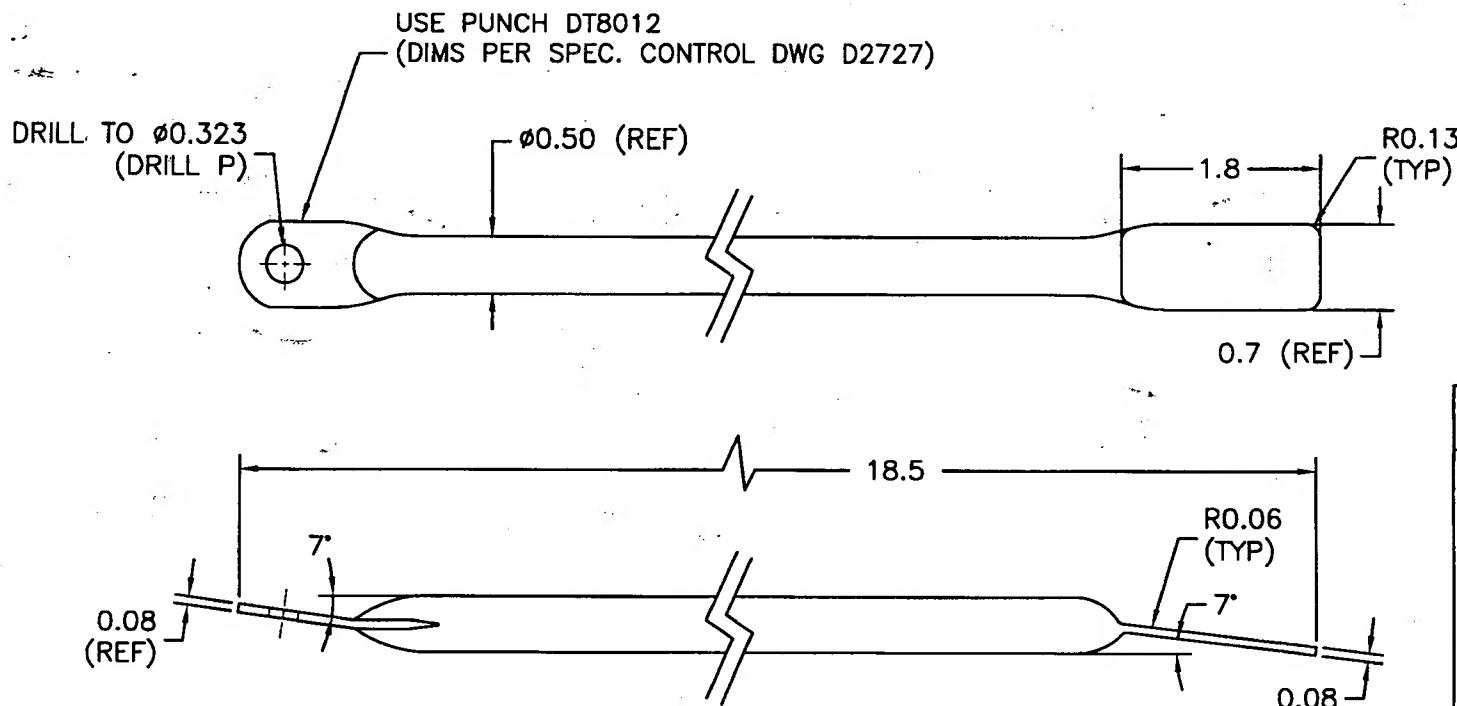
N

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**D3550-1 STRUT**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26226

NOTES:

- 1) MATERIAL: 304/316 SS SEAMLESS ROUND TUBE 0.500 OD X 0.049 WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3550-1 USING FINE POINT PERMANENT INK MARKER

RELEASED
07-02-27

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
PJH	MH	D3550	REV. B
DATE		TITLE	SHEET 1 OF 1
07.02.13		STRUT	SCALE
A	06.10.24	NEW ISSUE	NTS
B	07.02.13	18.5 WAS 20.13; 1.8 WAS 1.5	